

Date: Friday, 01/08/2008 3:31:09 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FRONT LEG FITTING ASS'Y	
<b>Job Number</b> :	40946			
<b>Estimate Number</b> :	13342			
<b>P.O. Number</b> :		<b>Part Number</b> :	D3762041	
<b>This Issue</b> :	01/08/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3762 REVA	
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	40945	<b>Drawing Revision</b> :	A	
	<b>Type</b> :	<b>Material</b> :		
	LARGE FAB ASSY	<b>Due Date</b> :	21/08/2008	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	JUD 08.8.05			
<b>Comment</b> :	Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-06-17 rev.A as per dwg DD verified:EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D37621	Fitting
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 Fitting  
 batch: B 41007 ✓ SP 08.08.19 (16x)

3.0	D37623	Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Tube  
 batch: B 41008 ✓ SP 08.08.19 (8x)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1  
 1-assemble as per dwg D3762 using locating pins DT9014 and tack weld parts in place  
 2- take pins out before welding  
 3-weld as per dwg D3762 per QSI004  
 Alum. rod Batch: M168037 ✓ SP 08.08.20 (8x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:31:09 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT LEG FITTING ASS'Y

Job Number: 40946

Part Number: D3762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC9	VISUAL WELDING INSPECTION
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PD 08-08-21

Comment: VISUAL WELDING INSPECTION

~~PD 08-08-20~~

6.0	QC5	INSPECT WORK TO CURRENT STEP
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PD

Comment: INSPECT WORK TO CURRENT STEP

8 08/08/21 (17)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF / FL 08-08-21 (17)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-21 (17)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BA

80 08/08/22 (7)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



MF 08-08-22

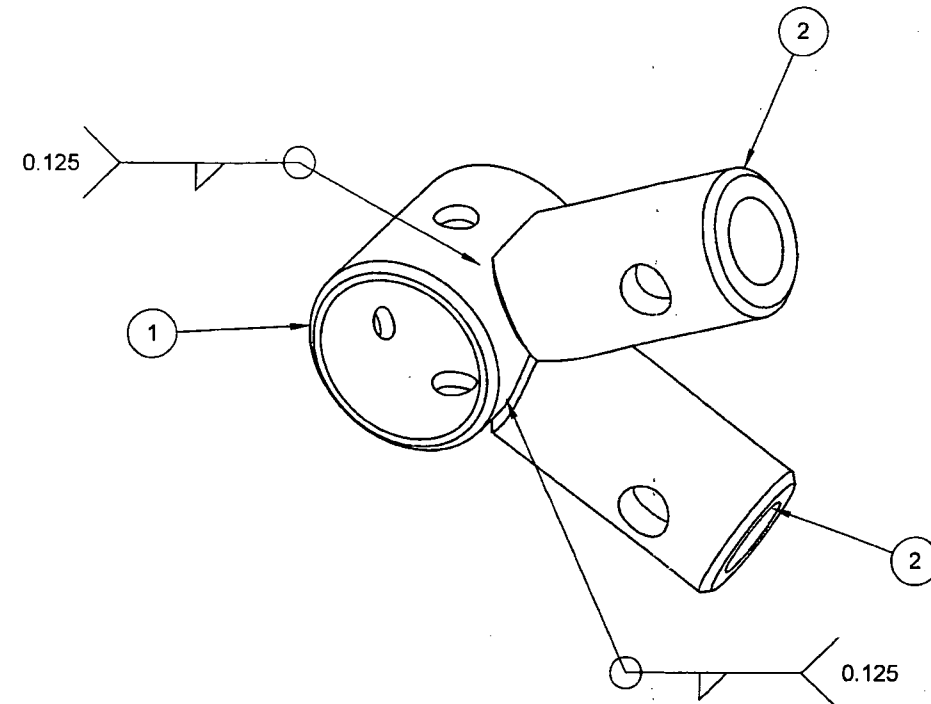
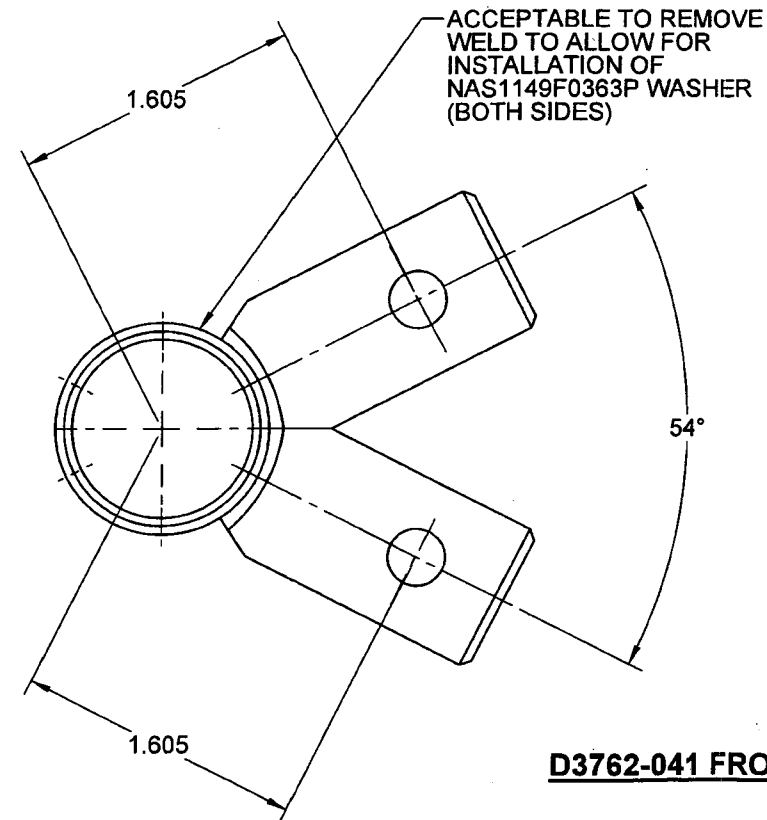
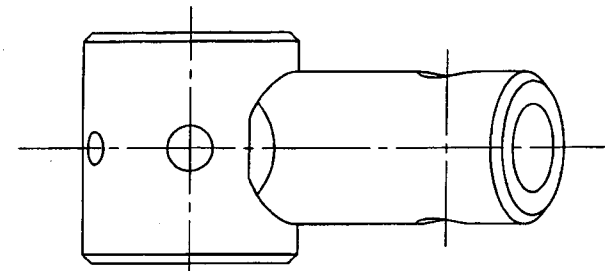
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3762-041 PAR #: 2/A Fault Category: LARGE FOS NCR: Yes No DQA: 1A Date: 08.08.22  
D3782-041/043/044 (D412-75-043/044) QA: N/C Closed: A Date: 08/08/2026

NCR: <u>40946</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/06/21</u>	<u># 6.0</u>	<u>During inspection one part found to have D3762-3 to be Squashed out of Round</u>	<u>[Signature]</u> <u>06/06/21</u>	<u>Scrap</u> <u>no Rep/rel</u>	<u>N/A</u>	<u>S</u> <u>06/06/21</u>	<u>[Signature]</u> <u>06/06/21</u>	<u>S</u> <u>06/06/21</u>
		<u>2. Part appears to have been "accidentally" dropped</u>	<u>[Signature]</u> <u>06/06/21</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>08.08.21</u>		<u>[Signature]</u> <u>06/06/21</u>	

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

# **D3762-041 FRONT LEG FITTING ASSY**

## **NOTES:**

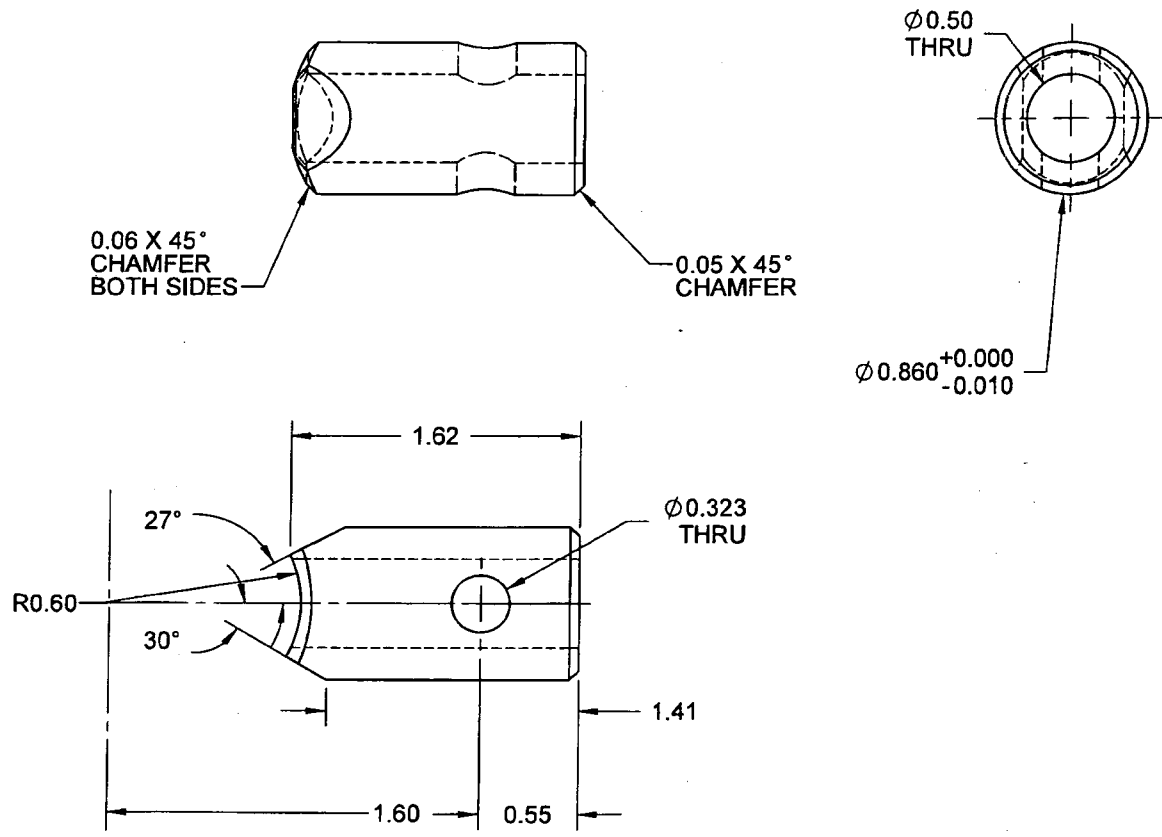
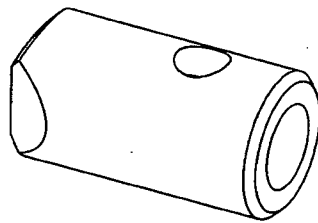
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

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08-05-16

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A		NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION			BY	DATE
DESIGN	HS	DART AEROSPACE LTD			
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D3762	SHEET 1 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.		FRONT LEG FITTING	NTS		
DATE	08.06.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

8 7 6 5 4 3 2 1



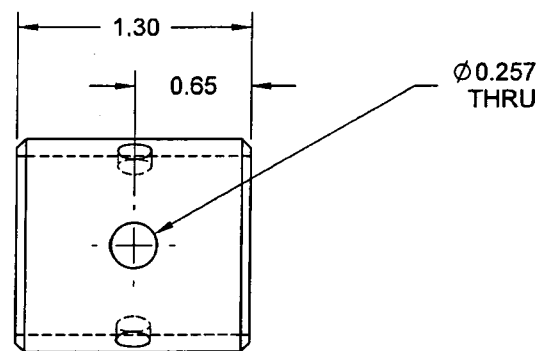
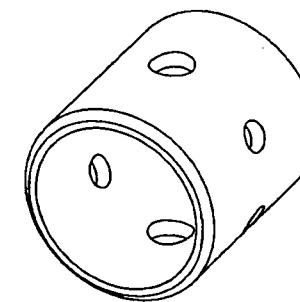
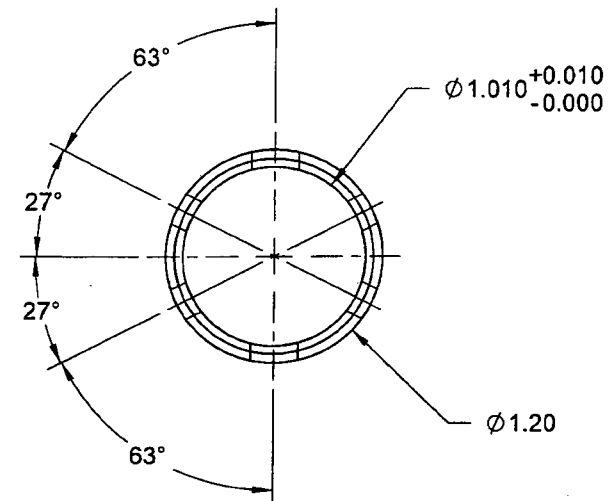
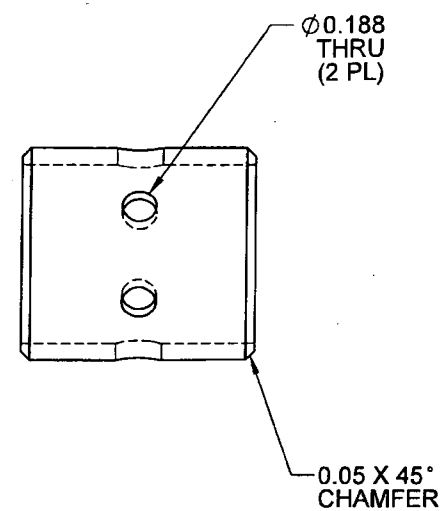
**D3762-1 FITTING**

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.02 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>MM</i>	DRAWING NO. <b>D3762</b>	REV. A
MFG. APPR.	<i>MM</i>	SHEET 2 OF 3	
APPROVED	<i>MM</i>	TITLE <b>FRONT LEG FITTING</b>	SCALE NTS
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DATE	<b>08.06.04</b>		

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08-06-16

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# **D3762-3 TUBE**

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## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3762	SHEET 3 OF 3
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